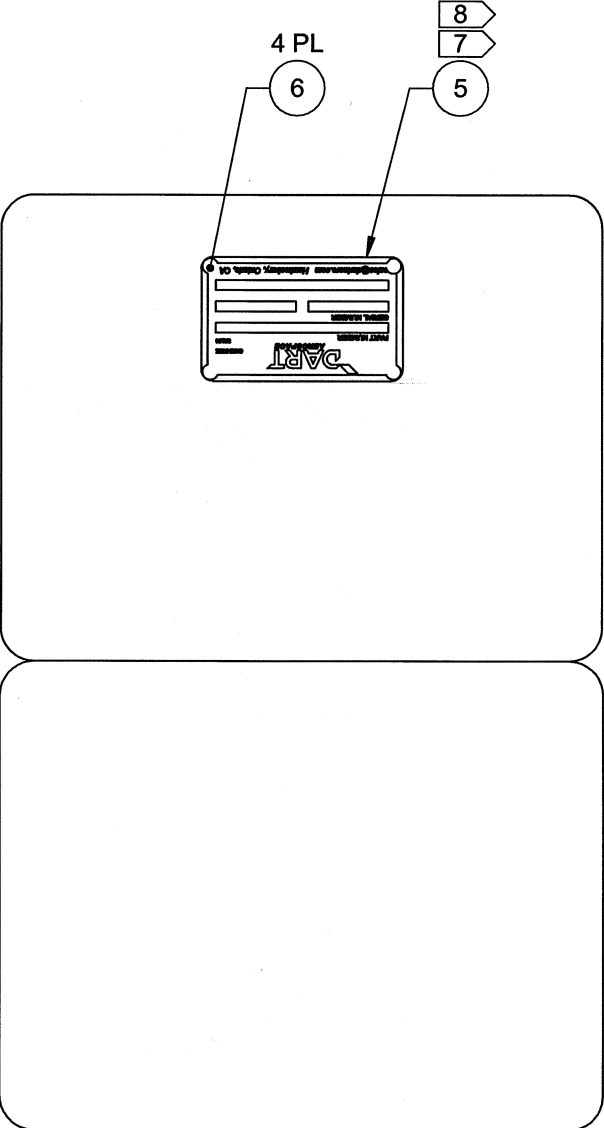
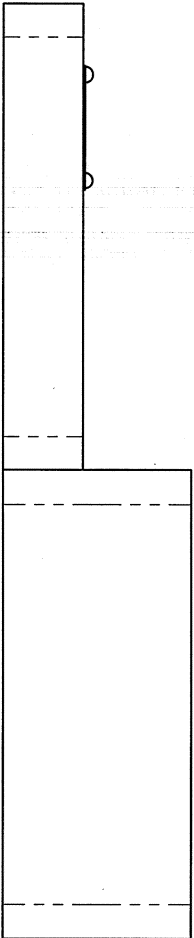
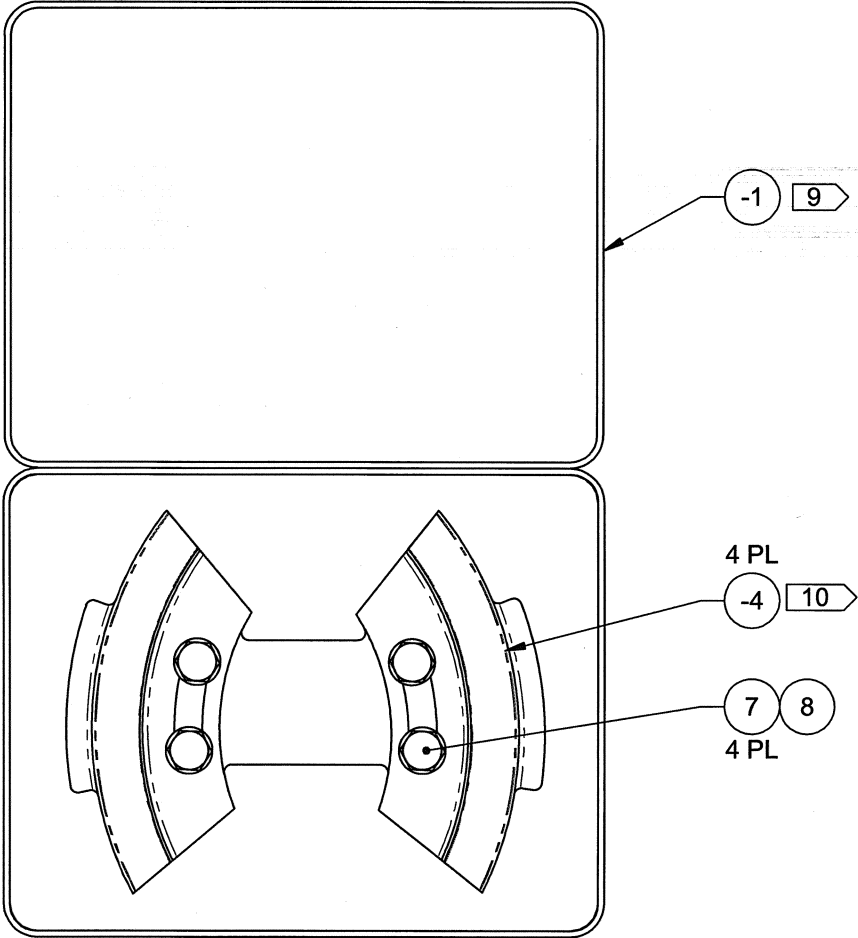


ITEM #	QTY	PART #	PART TITLE
-1	1	RBW6220G00131-8G-1	PACKAGING ASSY
-4	4	RBW6220G00131-8G-4	SLIDING RING
5	1	RB41011	DART PLACARD
6	4	McMaster#97524A032 OR EQUIV.	ALUMINUM SEALING BLIND RIVETS 1/8" DIA. X 0.425" LG.
7	4	AN7-10A	BOLT
8	4	NAS1149F0763P	STEEL WASHER 0.453" ID. X 0.750" OD. X 0.063 THK.



NOTES:

1) MATERIAL: N/A

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: N/A

7) IDENTIFICATION: ENGRAVE THE TOOL P/N & S/N ON THE DART PLACARD WHERE INDICATED

8) INSTALL THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA USING ALUMINIUM POP RIVETS

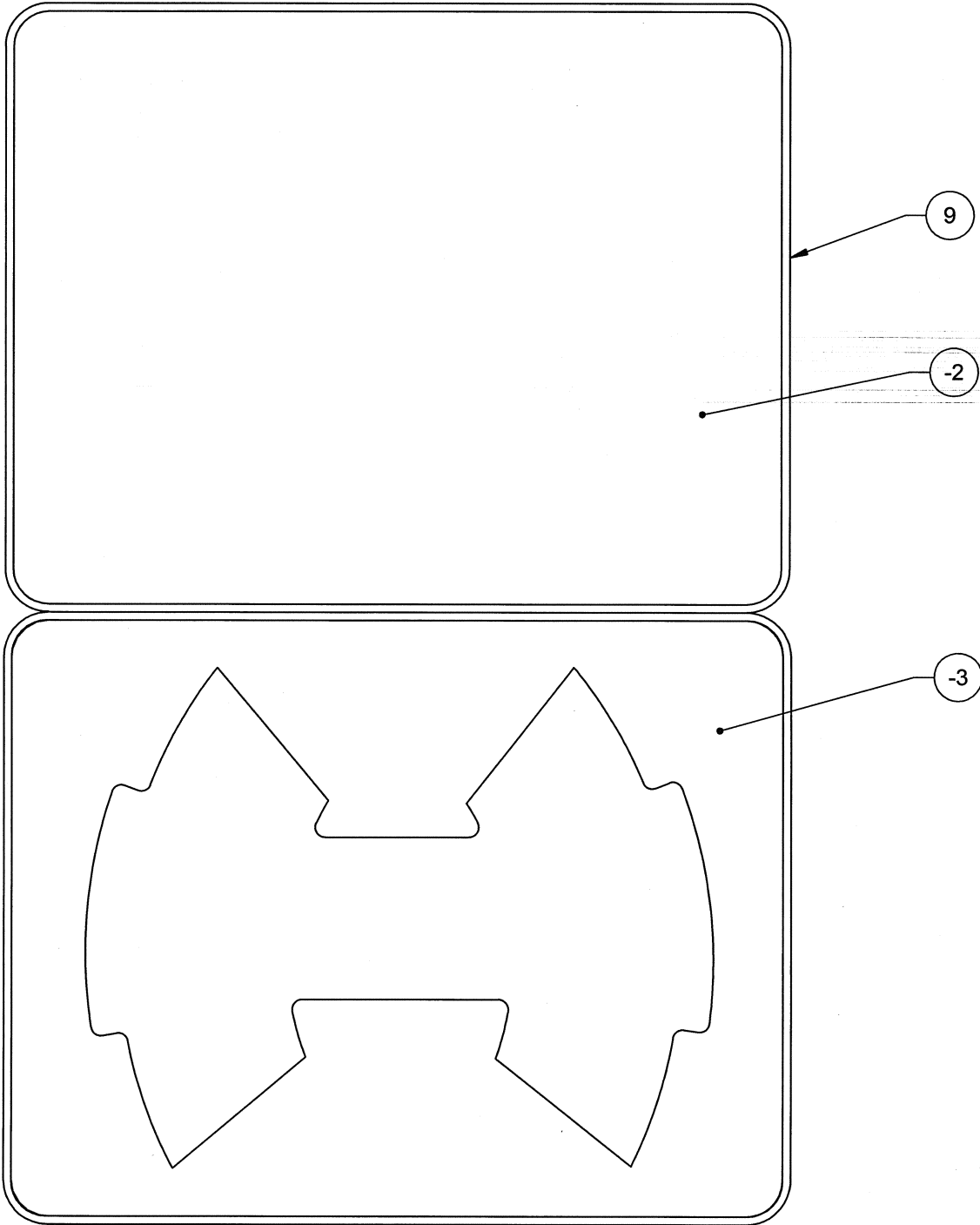
9) HOT GLUE THE TOP AND BOTTOM FOAM INTO THE CASE

10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

RBW6220G00131-8G MAIN ROTOR SLIDING RING CENTERING TOOL

A	NEW ISSUE	19-556	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	PK	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6220G00131-8G	SHEET 1 OF 5
APPROVED	WY	TITLE	SCALE
		MAIN ROTOR SLIDING RING CENTERING TOOL	NTS
DATE	2/4/2019	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM #	QTY	PART #	PART TITLE
-2	1	RBW6220G00131-8G-2	TOP FOAM
-3	1	RBW6220G00131-8G-3	BOTTOM FOAM
9	1	PELICAN #APP-1200-E	PELICAN CASE 1200



RBW6220G00131-8G-1 PACKAGING ASSY

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	PK	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6220G00131-8G	SHEET 2 OF 5
APPROVED	WY	TITLE	SCALE
DATE 2/4/2019		MAIN ROTOR SLIDING RING CENTERING TOOL	NTS
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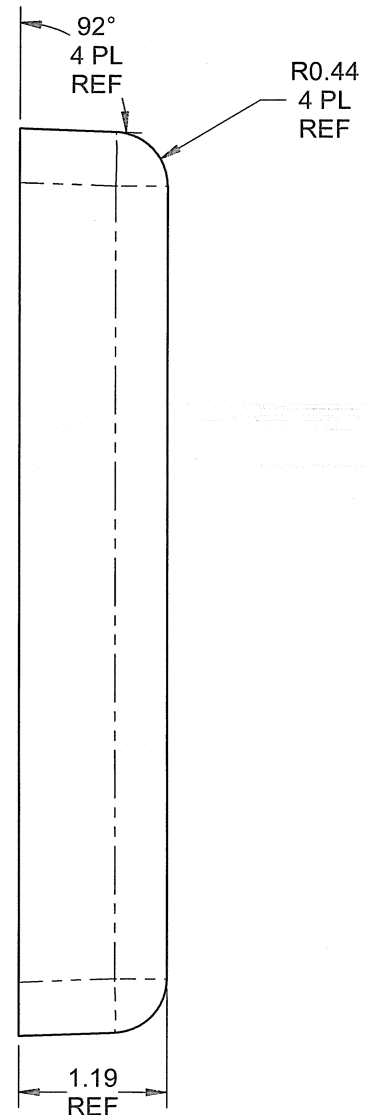
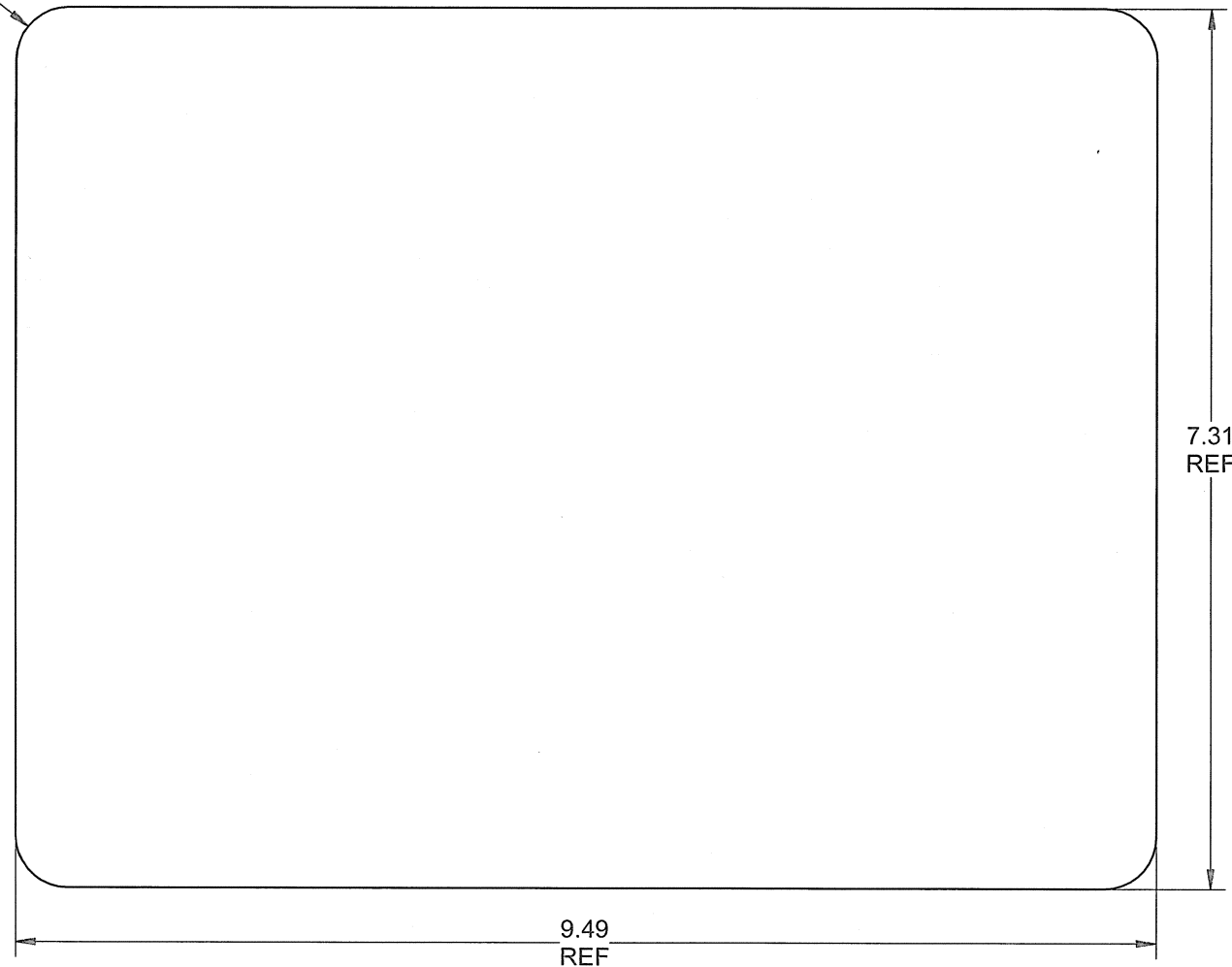
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A

RBW6220G00131-8G-2 TOP FOAM

NOTES:

1) MATERIAL: BLACK ETHAFOAM 220 REF

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°


PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

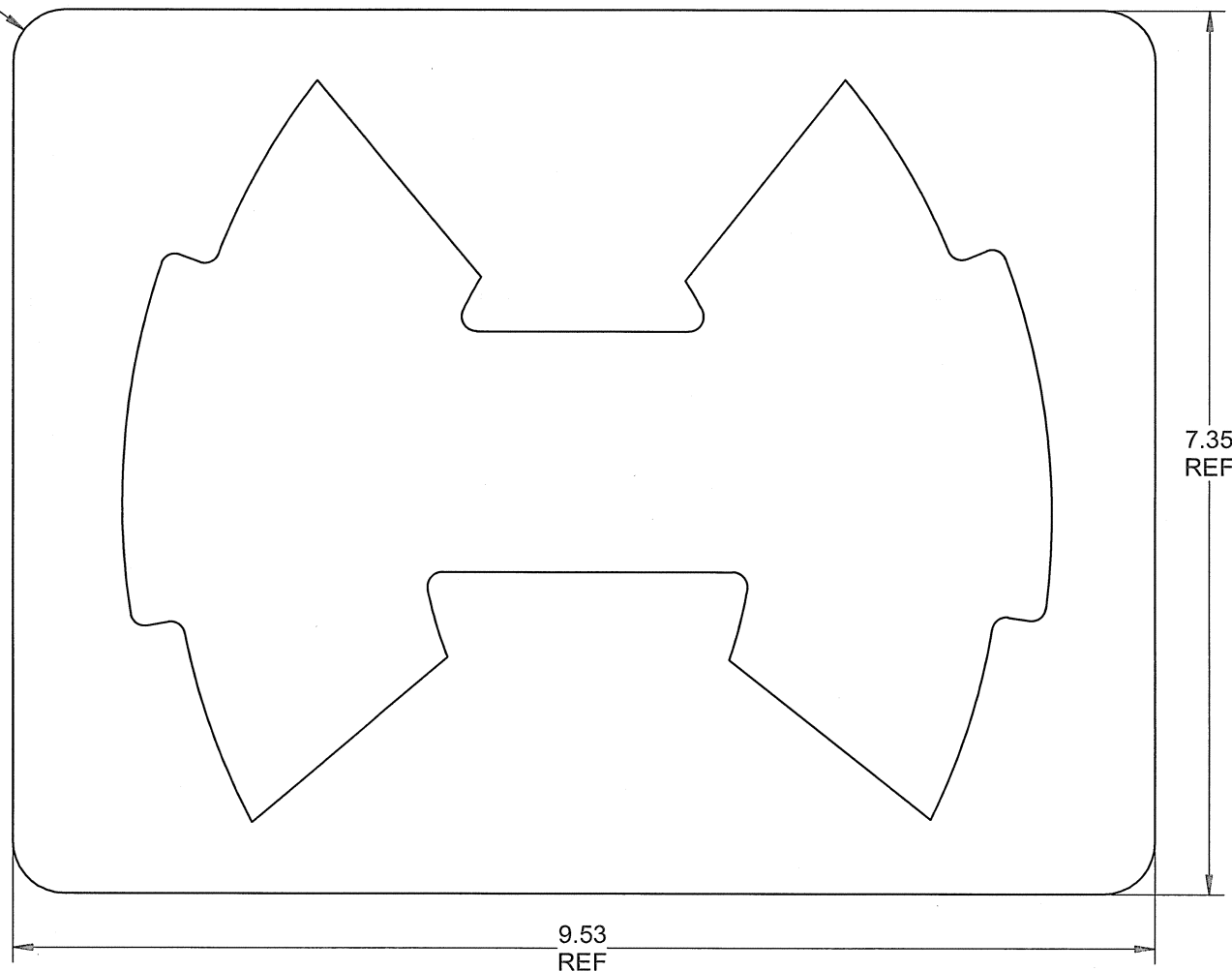
6) BREAK SHARP EDGES: N/A

7) IDENTIFICATION: N/A

8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RBW6220G00131-8G-2 REV A.STEP

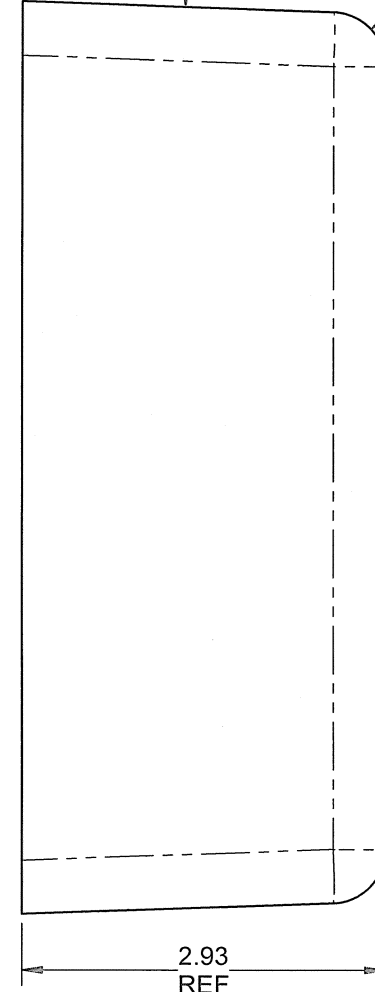
DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PK	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6220G00131-8G	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DATE 2/4/2019		MAIN ROTOR SLIDING RING CENTERING TOOL	NTS
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R0.44
4 PL
REF




92°
4 PL
REF

R0.44
4 PL
REF



RBW6220G00131-8G-3 BOTTOM FOAM

- NOTES:
- 1) MATERIAL: BLACK ETHAFOAM 220 REF
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RBW6220G00131-8G-3 REV A.STEP

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	PK	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6220G00131-8G	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DATE 2/4/2019		MAIN ROTOR SLIDING RING CENTERING TOOL	NTS
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